

ABSTRACT OF THE DISCLOSURE

Core sand elements are rapidly and reliably retained by driving one or more smooth surface fasteners, such as staples, nails or brads, into the core elements. In production, after the core sand elements are assembled, the core assemblies are placed on a moving belt conveyor, movement of core assemblies on the moving belt conveyor is intercepted and momentarily stopped at a fastening station and the momentarily stopped core assemblies are lifted from the moving belt conveyor to a fastening position at which a plurality of smooth surface fastener guns are moved into position against the core assembly and located to simultaneously drive a plurality of smooth surface fasteners into the core elements of the core assembly. In preferred such methods, the smooth surface fastener comprises a staple with two smooth surface tines connected by a crown and the staple is positioned for insertion of one tine into each of two adjacent core elements with the crown of the staple spanning the interface between the two core elements.